



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

269T9211-003
Job Sheet 175128



Part No: 269T9211-003

Job Qty: 4 ea

Part Name: Drive Shaft Coupling Adapter Spanner Wrench



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/27/18

Job Tracking No:

Due Date: 4/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 269T9211 Rev 0 IPP Rev A 18.03.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		4/4/18	0.00	0.00	Start Up Machining-3		
110	Lathe Conv	4 pcs		4/4/18	0.00	2.00	Lathe Conv-1		
120	QC	4 pcs		4/4/18	0.00	0.00	QC2 Machining-4		
130	Mill Conv	4 pcs		4/4/18	0.00	1.00	Mill Conv 1		
140	QC	4 pcs		4/4/18	0.00	0.00	QC2 Machining-4		
150	QC	4 pcs		4/4/18	0.00	0.00	QC8 Machining-4		
160	Large Fab	4 pcs		4/5/18	0.00	1.00	Large Fab 3		
170	QC	4 pcs		4/5/18	0.00	0.00	QC9		
175	QC	4 pcs		4/5/18	0.00	0.00	QC5		
180	Outsource	4 pcs		4/5/18	0.00	0.00	Outsource12		
190	Packaging	4 pcs		4/5/18	0.00	0.00	Packaging2		
200	QC	4 pcs		4/5/18	0.00	0.00	QC6		
210	Packaging	4 pcs		4/5/18	0.00	0.00	Packaging3-1		
220	QC21-SA	4 Ea		4/5/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine socket to length as per DWG. 2-Deburr

Descriptions: 130 - 1-Spot face wrench to create flat surface for welding, use socket for sizing.

160 - 1-Weld as per DWG. Ensure proper positioning prior to welding. 2-Remove oil and black oxide as required

175 - Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

180 - Issue P/O to Groupe Altech; PO NA -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
7220H	Socket	4 Ea (1 ea)	90-Start up Operation	5056156
C471	Adjustable Spanner Wrench	4 Ea (1 ea)	130-Mill Conv	5056155

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	7220H	4	0	0
130-Mill Conv	C471	4	0	0

Part Specifications



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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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Container No: S059192



Part: 269T9211-003

Job No: 175128

Serial No/Batch: S059192

Revision: 0

Inspector:

Date: 04/09/18

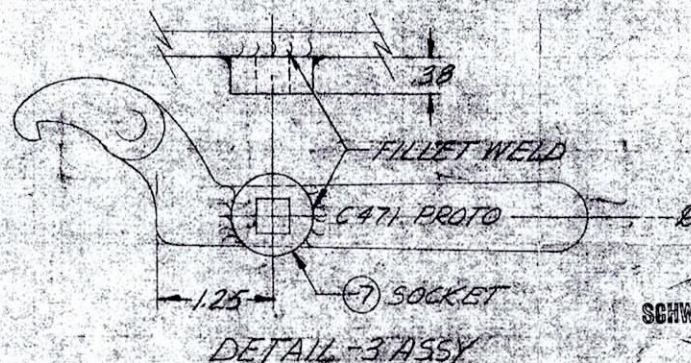
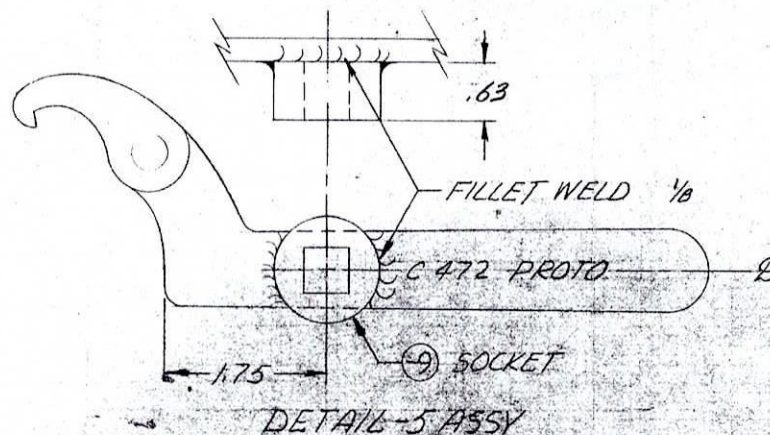
04-23-2018

Specifications could not be found.

Plex 3/27/18 1:49 PM Dart.lajeunesse.marie

Ordn 1 1731

REVISIONS					
ZONE	SYM	EFF. ON	DESCRIPTION	DATE	APPROVED
REV.			1. MAY BE REWORKED 3. RECORD CHANGE 2. SCRAP 4. TOOLING AFFTD 5. OK TO USE	0-04-00	
A			CHANGED DWG. NO. WAS 269A9211	3 B McI 3/23/91	<i>[Signature]</i>



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SCHWEIZER AIRCRAFT CORP
ELMIRA, NY

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PROD. RELEASE

4. PAINT FLAT BLACK ALL OVER.
3. USED IN CONJUNCTION WITH TORQUE
WRENCH IN T.R. & M.R. TRANS.
OVERHAUL
2. BAG OR TAG IDENTIFY
1. WELD PER HP11-1
NOTES:

				1		006	C472	ADJ SPANNER WRENCH				PROTO TOOL CO.	
					1	005	C471	ADJ SPANNER WRENCH				PROTO TOOL CO.	
				1		004	7426 H -9	SOCKET	1 3/8 INCH 12 SQ DRIVE	MAKE FROM	COMM'L		
					1	003	1220 H 7423 L H -7	SOCKET	5/8 INCH 3/4 SQ DRIVE	MAKE FROM	COMM'L		
						002	-5	WRENCH ASSY					
						001	-3	WRENCH ASSY					
						NEW NO.	PART NO.	NAME	SIZE	DESCRIPTION	SPECIFICATION	ZONE	
				QTY	REQ'D	-5	-3						
LIST OF MATERIAL													

				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				CONTRACT NO.			
				DIMENSIONAL TOLERANCES 2 PLACE DECIMAL $\pm$.010				DRAWN <i>R. BLOCKER</i>			
				3 PLACE DECIMAL $\pm$.005				CHK'D <i>R. BLOCKER</i>			
				CONV. DIM. ☒ YES ☐ NO				APP'D <i>R. BLOCKER</i>			
				MATERIAL INFORMATION BY MATERIAL AND PROCESS				APP'D <i>R. BLOCKER</i>			
				ALL REPRODUCTION, DISSEMINATION AND DISCLOSURES STRICTLY FOR- HIDDEN WITHOUT THE EXPRESS WRITTEN PERMISSION OF SCHWEITZER AIRCRAFT.				APP'D <i>R. BLOCKER</i>			
				ALL RIGHTS RESERVED BY SCHWEITZER AIRCRAFT.				HTCAD APPROVAL			
				COPYRIGHT SCHWEITZER AIRCRAFT.				APPROVAL			
ITEM QTY MODEL NEXT USING DRAWING END ITEM NO. $\pm$ THRU				HUGHES TOOL COMPANY-AIRCRAFT DIVISION CULVER CITY, CALIFORNIA				NCH-ADJUSTABLE INNER, T.R & M.R. TRANS. RHALL			
REQD PER END ITEM EFFECTIVE ON				SIZE CODE IDENT NO. DWG NO.				C 02731 269T9211 (A)			
APPLICATION (USAGE) DATA				SCALE FULL				SHEET			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					